

5/26

<b>DART AEROSPACE LTD.</b>	<b>Work Order:</b>	23508
<b>Description:</b> Saddle Fitting, Fwd (Outboard/Inboard)	<b>Part Number:</b>	D2571/D2572
<b>Drawing:</b> D2571 Rev. D/D2572 Rev. D	<b>Qty:</b>	8
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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <b>Dwg not required</b>	PH	05.06.06	8
2	MV	Make from D6101-007 billet for D2571 <b>Ensure that grain is along 7.75" length</b> Batch No: B23250	EE	05.06.18	8
3	MV	Make from D6101-005 billet for D2572 <b>Ensure that grain is along 5.00" length</b> Batch No: B23249	EE	05.06.18	8
4	MV	Fixturing W/O No. _____ Fixturing Inspection last completed _____ by _____	N/A		8
5	MV	Program Batch No. <u>B23249</u> Double check by: <u>ML</u>	BC	05.06.22	8
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	BC	05.06.22	8
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	BC	05.06.22	8
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	BC	05.06.22	8
9	MV	Machine keyway as per dwg D2571 & D2572	BC	05.06.22	8
10	MV	Deburr and remove all machining marks	BC	05.06.22	8
11	MV	Tumble for 20 minutes to remove sharp edges # 04.06.21	BC	05.06.22	8
12	QC1	Inspect all dimensions to dimension sheets	BC	05.06.22	8
13	QC7	Second inspection	ML	05/06/22	8
14	FP	Acid etch and alodine as per QSI 005 4.1	ML	05/07/04	8
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	FL	05/07/05	8
16	QC3	Inspect Powder Coat	ML	05/07/06	8
17	ST	Identify and Stock.	CL	05/07/06	8
18	AC	Cost / Part 181.11 144.18	SUE	05/08/02	8
19	DC	Close W/O 168.80 145.12 Inspection Level 21	PH	05/07/07	8

Rev	Date	Change	Revised By	Approved
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	
I	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ RF	

RELEASED  
02/10/15 RF

